

# Work Order ID 72619

Wednesday, August 03, 2011 3:47:59 PM



Page 1

Item ID: D3997-21

Accept



Setup Start



Revision ID:

Item Name: Placard

Stop



Start Date: 8/3/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 8/4/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date: 11-08-3

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3997

A

100

0.00



Purchasing

Memo

0.00

Purchasing

Issue P/O: 14642  
Manufacture as per Dwg D3997  
Possible Supplier: Studio Lettrage  
Material release note required

11-08-3  
10

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

11/8/11 14

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

Dulochi

412

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 72619**

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Item ID: D3997-21

Accept

Setup Start

Revision ID:

Stop

Item Name: Placard

Start Date: 8/3/2011 Start Qty: 10.00

Cust Item ID:

Required Date: 8/4/2011 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg & Stock Location: 104

0.00



Packaging

Memo

0.00

Packaging

11/8/11

(12)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 11/08/12

11-08-12 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, August 03, 2011 3:48:04 PM

Page 1

Work Order ID: 72619



Parent Item: D3997-21



Parent Item Name: Placard



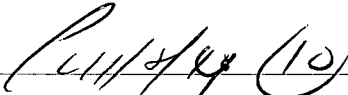
Start Date: 8/3/2011

Required Date: 8/4/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A 10.01.12 new issue Prelim EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3997-21P  Placard		Purchased	No				Each	0.0000		10			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

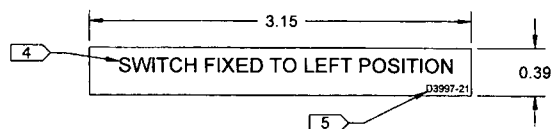
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

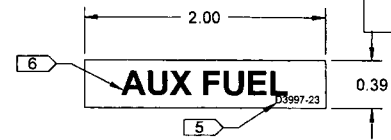
**NOTE:** Date & initial all entries

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D3997-21	JCA-M47-P13
D3997-23	JCA-M47-P14
D3997-25	JCA-M47-P15
D3997-27	JCA-M47-P16

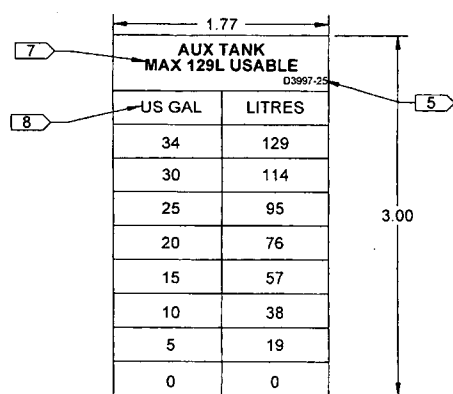
PART NUMBER	INSTALLATION INSTRUCTIONS
D3997-21	ON AUX FUEL GAUGE SWITCH PLATE
D3997-23	ON AUX FUEL GAUGE
D3997-25	NEXT TO AUX FUEL GAUGE (AS 350 ONLY)
D3997-27	NEXT TO AUX FUEL GAUGE (EC 130 ONLY)



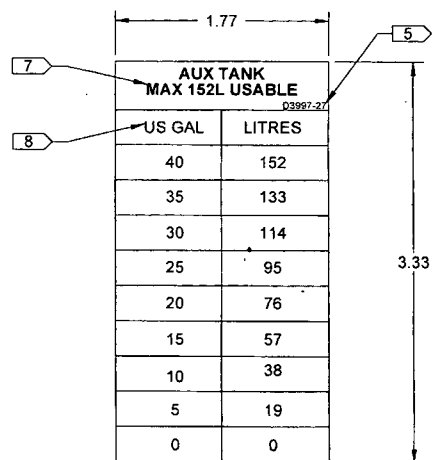
**D3997-21 PLACARD**



**D3997-23 PLACARD**



**D3997-25 PLACARD**



**D3997-27 PLACARD**

**RELEASED**  
2010-01-11

- NOTES:
- 1) MATERIAL: 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
  - 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 3) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 4) 12 PT FONT, WHITE TEXT ON BLACK BACKGROUND
  - 5) 6 PT FONT, WHITE TEXT ON BLACK BACKGROUND
  - 6) 20 PT BOLD FONT, WHITE TEXT ON BLACK BACKGROUND
  - 7) 10 PT BOLD FONT, WHITE TEXT ON BLACK BACKGROUND
  - 8) 10 PT FONT, WHITE TEXT ON BLACK BACKGROUND

DESIGN		<b>DART AEROSPACE LTD</b>
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. <b>D3997</b> REV. A
MFG. APPR.		SHEET 4 OF 6
APPROVED		TITLE <b>PLACARD</b> SCALE
DE APPR.		NTS
DATE	09.10.05	COPYRIGHT © 2009 BY DART AEROSPACE LTD
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# Studio de Lettrage

210 Main Street W  
Hawkesbury, Ontario K6A 2H6

## INVOICE

Invoice No.: 16152  
Date: 08/08/2011  
Ship Date:  
Page: 1  
Re: Order No. 11242

**Sold to:**

Dart Aerospace Ltd  
1270 Aberdeen  
Hawkesbury, Ontario  
K6A 1K7

**Ship to:**

Dart Aerospace Ltd  
Hawkesbury, Ontario

Business No.: 82500 7651 RT0001

Item No.	Unit	Quantity	Description	Tax	Unit Price	Amount
		10	D3997-3P setup	H	5.00	50.00
		100	D3997-5P set up	H	0.50	50.00
		10	D3997 7P set up	H	5.00	50.00
		10	D3997 -9P set up	H	5.00	50.00
		10	D3997-11P setup	H	5.00	50.00
		10	D3997-13P set up	H	5.00	50.00
		10	D3997-15P set up	H	5.00	50.00
		10	D3997-17P set up	H	5.00	50.00
		10	D3997-21P set up	H	5.00	50.00
		10	D3997-23P set up	H	5.00	50.00
		10	D3997-27P set up	H	5.00	50.00
		10	D3997-29P set up	H	5.00	50.00
		10	D3997-31P set up	H	5.00	50.00
		10	D3997-33P setup	H	5.00	50.00
		10	D3997-35P setup	H	5.00	50.00
		10	D3997-37P setup	H	5.00	50.00
		10	D3007-39P setup	H	5.00	50.00
		10	D3997-41P setup	H	5.00	50.00
		10	D3997-43P setup	H	5.00	50.00
		1	printing	H	450.00	450.00
			H - HST 13%			
			HST			182.00
			PST Exempt: #6122-5207			
Studio de Lettrage HST: #869034678RP001						
Shipped By: Tracking Number:						
Comment: PO 14612						
Sold By:						
Total Amount						1,582.00





# Scotchcal™

## Opaque Imaging Media 8522

### Description

This media is specially formulated to dry quickly after printing. Production of outdoor weatherable and long-term indoor durable graphics is now easier than ever. Its changeable adhesive allows easy removal for up to one year.

### Advantages

- Optimized for use with selected Epson Stylus Pro printers and Epson Archival inks.
- Optimized for use with selected HP DesignJet Printers and HP DesignJet Ink System UV or HP83UV Color Ink System
- For making opaque, laminated graphics that are outdoor weatherable and long-term indoor durable
- Media:
  - For opaque (reflective) graphics
  - Changeable, easy to remove from warranted substrates up to 1 year later
  - Dries quickly after printing so the overlamine can be applied almost immediately
  - Low slippage paper liner for superior tiling
- Overlaminates:
  - Provide additional UV (ultraviolet) and physical protection for making weatherable finished graphics
  - Available in luster and matte gloss
  - Adhesive allows for heat-assisted or cold-temperature lamination

### Applications and Uses

3M™ Scotchcal™ Changeable Opaque Imaging Media 8522 is intended only for ink jet printing and for use with the listed Compatible Products and Equipment and the following applications. Any other application is NOT warranted by 3M or covered by the worldwide 3M™ MCS™ Warranty unless 3M gives its prior written approval for the application.

- First surface images (the image is on top of the film) for opaque posters and signs, including:
  - Graphics for vans, personal vehicles, trucks and buses
  - Novelty posters
  - Retail and point-of-purchase displays
  - Information graphics such as maps and directories
  - Entertainment promotions in museums, zoos, parks, theatres, sports venues
  - Education and presentation graphics

### Product Bulletin 8522

Release F, Effective January 2003  
Black bar in margin indicates a change

- Legal and courtroom exhibits

- For flat or simple curved surfaces, with or without rivets, used in vertical ( $\pm 10^\circ$ ) applications

### Limitations of End Uses

The following uses and applications are specifically NOT warranted.

- Fleet applications in areas that use salt for winter road maintenance
- Application to non-warranted substrates, including wall-board
- Applications subjected to gasoline vapors or spills
- Application to corrugated or highly irregular surfaces or sharply raised areas
- Graphics applied to stainless steel, including stainless steel vehicles
- On flat surfaces with rivets, tenting of 4 to 10 mm around rivets may be expected; rivets may be cut around to eliminate tenting.

Note: Standard ink jet technology is water based. Water-based chemistry is susceptible to the extremes of heat and humidity. This is a factor in most product constructions on the market. Read the Fabrication, Shelf Life and Storage sections in this bulletin. Staying in the middle of these ranges always provides optimum performance.

### Compatible Products and Equipment

#### Thermal Ink Jet Printing Systems

- Epson Stylus Pro 9500, Stylus Pro 10000 printer
  - Epson Archival Inks
- Epson Stylus Pro 10600 printer
  - Epson Archival Inks
- HP DesignJet Printers 2000 and 3000 series
  - HP DesignJet Ink System UV (pigment-based ink)
- HP DesignJet Printers 5000 series
  - HP83UV Color Ink System

#### Overlaminates (required)

- 3M™ Luster Overlamine 8519 (semi-gloss)
- 3M™ Matte Overlamine 8520

Note: For the full product names of the 3M products listed on this page, please see page 1.

### Warranted Substrates

Media 8522 is warranted for use on the following rigid substrates.

Some substrates may "out-gas", resulting in tiny bubbles throughout the surface of the graphic. For maximum performance, be sure the substrate you select is properly cleaned and prepared as recommended by the manufacturer. See Instruction Bulletin 5.1 for additional information.

- Alodine (anodized aluminum)
- Automotive panels (automotive painted steel)
- Fruehauf (painted aluminum)
- FRP (fiberglass reinforced plywood)
- Glass
- Imron® (polyurethane-painted metal panel)
- Acrylic
- Sintra® board

### Test and Approve Non-warranted Substrates Before Use

Media 8522 is not warranted for any substrate other than those listed above. If you want to use it for other substrates, 3M recommends that you test and approve the media for both adhesion and removal characteristics.

### Characteristics

Characteristic	Description
Media	7 mil, white, opaque graphic film
Liner	Low-slippage, lay flat paper
Adhesive	Changeable, pressure sensitive
Thickness (media and adhesive)	7.5 to 8 mil (nominal)
Application substrates	See Warranted Substrates, above
Application surfaces	Flat or simple curved surfaces, with or without rivets, used in vertical ( $\pm 10^\circ$ ) applications (no corrugations)
Application temperature range	28° to 110°F (-2° to 43°C) (air and surface)
Roll sizes	36" x 45 feet (914 mm x 13.5 m) 54" x 45 feet (1372 mm x 13.5 m)

## How to Become a 3M Ink Jet Registered Fabricator

Only 3M Thermal Ink Jet Registered Fabricators are eligible to offer 3M MCS warranted graphics. In order to become certified, a fabricator must complete the requirements as specified in the 3M Ink Jet Graphics Registered Fabricator Reference Manual located on the 3M website at [www.scotchprint.com](http://www.scotchprint.com)

### Effective Performance Life

To obtain the warranty given below, the graphics must be made according to 3M's recommendations which are detailed in the Warranty and Limited Remedies on page 3. Also see the section, Removability.

### Warranted Durability

Media 8522 with Overlaminates 8519 or 8520	Epson Printers		HP Printers	
	Outdoor	Indoor	Outdoor	Indoor
Applied to Warranted Substrates	2 years	5 years	3 years	5 years

### Removability

Imaging media 8522 is removable from warranted substrates for 1 year without the aid of chemical strippers or accessories. Refer to Instruction Bulletin 4.23 for additional information.

### Fabrication

Graphics must be made according to 3M's recommendations which are detailed in the Warranty and Limited Remedies on page 3.

See Instruction Bulletin 4.23 for detailed fabrication, printing and mounting information.

### Graphic Construction Options

#### Opaque (Reflective) Graphics

Opaque graphics made with imaging media 8522 require an overlaminate and an opaque substrate.

